

Work Order ID 115283

March-24-14 10:02:19 AM

\*115283\*

~~PRELIMINARY ISSUE~~

Page 1

Item ID: D4542-2

Revision ID:

Item Name: Retainer, Inner, RH

Start Date: 3/24/14 Start Qty: 10.00 \*10\*

Required Date: 3/25/14 Req'd Qty: 10.00 \*10\*

Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan: W Date:

QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

DAS  
27  
9-89

DAS  
10  
9-89

D4542

PEZ ROSE

100

\*100\*

Waterjet

FLOW CNC Waterjet

Memo

1- Cut as per dwg

Prog rev: PEZ

Dwg rev: PEZ

2- Deburr

0.00

0.00

10 0 Jm14-03-25

110

QC2- Inspect parts off machine FAI/FAIB

\*110\*

QC

Quality Control

Memo

0.00

0.00

10 0 Jm14-03-25

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Item ID: D4542-2

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Start Date: 3/24/14 Start Qty: 10.00

Required Date: 3/25/14 Req'd Qty: 10.00

Reference:

Accept

\*N900040100\*

Setup Start

\*NS1\*

Stop

\*NS2\*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

QC:

Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start

\*NR1\*

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

DAS

\*120\*

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location:

0.00

\*130\*

Packaging

Memo

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

\*140\*

QC

Memo

Quality Control

POSITIVE RECALL

EFFECTIVE

RELEASED

16  
9-89

AUTH

DATE

14/03/26

DAS  
27  
9-89

14/3/26

MAR 27 2014

MLJ 14-03-26

MF 11-3-26

Release Dwg as per  
Dwg Rev E

14/03/26

121- Alodine as per Q52005 10 7/6/14/3/26

122- Qc7 inspect diameter cont.

533?

14/3/26

14/3/25

10  
Impact as per  
Dwg PFD

10

DAS  
06  
9-89

# Picklist Print

March-24-14 10:02:18 AM

Page 1

Work Order ID: 115283

**\*115283\***

Parent Item: D4542-2

**\*D4542-2\***

Parent Item Name: Retainer, Inner, RH

Start Date: 3/24/14

Required Date: 3/25/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP revA 12.01.12 New Issue EC verified by:DD IPP REV:B  
 12.02.24 as per dwg revA DD verf:EC IPP REV:C 12.05.08 as  
 per dwg revB DD verf:EC IPP REV:D 13.04.23 as per dwg  
 revD DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.032

Purchased

No

sf

401.2832

9

**\*M6061T6S 032\***

\*\*

Jm14-03-25

6061-T6 Sheet 0.032"

Location

Loc Qty

Loc Code

MAT021

401.28317

123483

8.57

m125822

17

m127272

119.43317

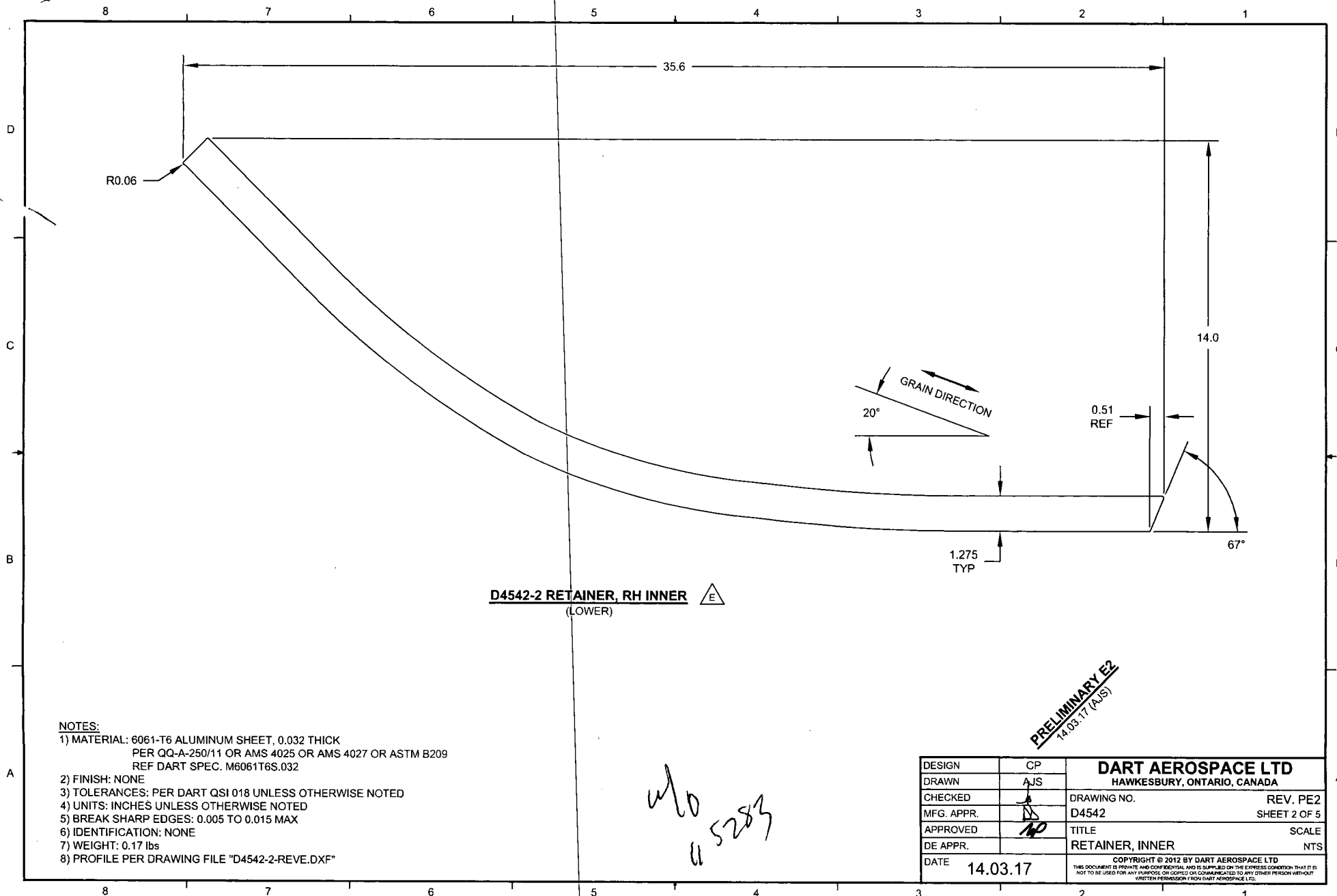
m128054

256.28

128054









8

7

6

5

4

3

2

1

D

D

R0.06

35.6

14.0

C

C

GRAIN DIRECTION

20°

0.51  
REF

67°

B

B

1.275  
TYP**D4542-2 RETAINER, RH INNER**  
(LOWER)

## NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK  
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC. M6061T6S.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.17 lbs
- 8) PROFILE PER DRAWING FILE "D4542-2-REVE.DXF"

RELEASED  
2014-03-16  
AND

DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4542	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, INNER	NTS
DATE	14.03.17	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8

7

6

5

4

3

2

1

A

A